



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-300
Job Sheet 169871



Part No: SWA10A-300

Job Qty: 6 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 1/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA10A-300 Rev 5

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-3		
100	Bandsaw	6 pcs	1/11/18	1/11/18	0.00	0.60	Bandsaw1		
110	Mori Seiki	6 pcs	1/12/18	1/12/18	0.00	6.00	MORI NLX		
120	QC	6 pcs	1/12/18	1/12/18	0.00	0.00	QC2		
130	QC	6 pcs	1/12/18	1/12/18	0.00	0.00	QC8		
140	Packaging	6 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3	GA	
150	QC21-SA	6 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 3.560"

Descriptions: 110 - 1-Machine as per DWG. FB711 FOLIO REV: _____ DWG REV: _____ 2-Deburr

DWG
21
9-09

JAN 6 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R4.000	2	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/2/18 12:58 PM Dart.lajeunesse.marie

3.44 hrs

9.4 hrs

1.813
S 030422



S034295



Bearing Housing

PART NO:

Original Serial #: **S034295**

Revision:

Operation:

Change No:

SWA10A – 300

Start up Operation

01/22/18

Job No: 169871

Dart Aerospace Ltd.
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DART AEROSPACE LTD		Work Order: 169871
Description: Bearing housing		Part Number:
Inspection Dwg: SWA10A-300 Rev: 5		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.235	+0.003/-0.000	1.237	✓		Vern LPOB	
.125	±0.005	.125				
1.020	±0.005	1.019				
.245	±0.005	.249				
1.017	±0.005	1.021				
.095	±0.005	.095				
.03x45°	±0.01x.5°	.03x45°				
.02x45°	±0.01x.5°	.02x45°				
Ø2.165	±0.001	2.165			Mic LPOB	
Ø2.3521/2.3520		2.3526			NLX 2500	
R.015	±0.005	.015			Vern LPOB	
Ø3.071	+0.003/-0.000	3.072			Mic 104-137	
Ø3.120	±0.005	3.120			↓	
Ø3.500	±0.010	3.521			Mic 112-177	
.120	+0.005/-0.000	.1215			Vern LPOB	
3/2 160N-113	GO - NO GO	GO			GO gage	
Ø3.505	+0.001/-0.002	3.505			Mic 104-137	
Ø3.710	±0.006	3.709			Mic 112-177	
Ø3.950	±0.005	3.951			Mic 104-137	
3.430	±0.005	3.430			Height gage	
.680	±0.005	.679			↓	
Ø2.70	±0.01	2.702			Vern LPOB	
R.25	±0.01	.250			Rad gage	
.07x45°	±0.01x.5°	.07x45°			Vern LPOB	
.04x45°	±0.01x.5°	.04x45°			↓	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18-01-22	Date: 18/01/25	Date:

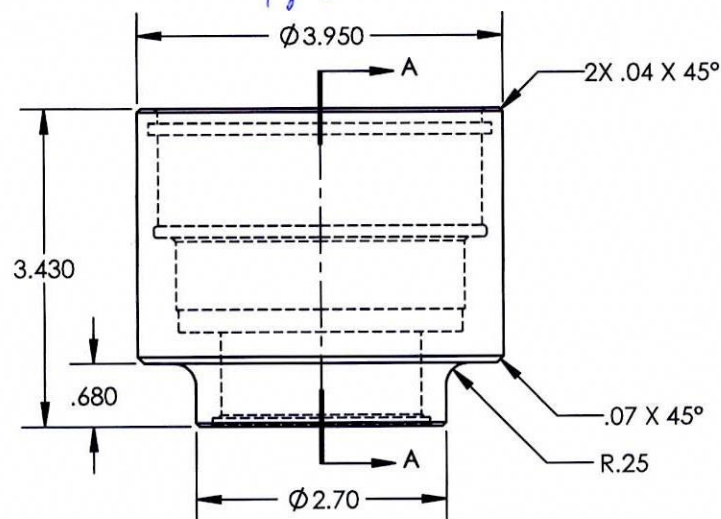
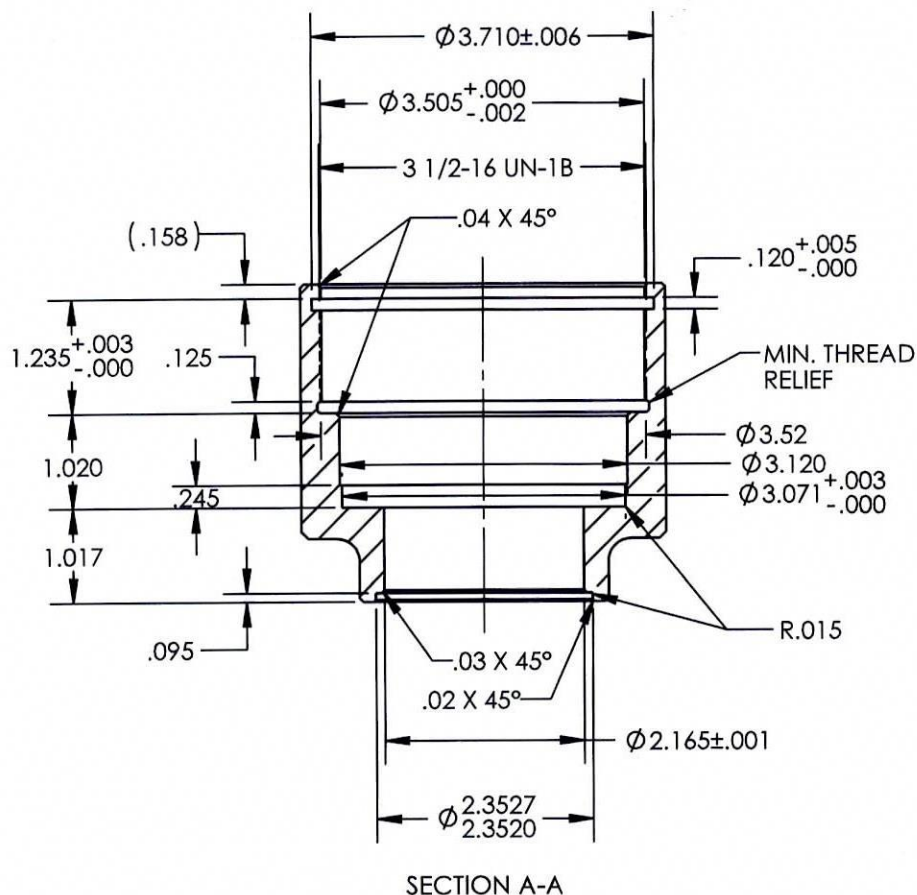
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		AS DRAWN BY CANAM	11/12/2012	JAG
3		CH'D TOLERANCE OF Ø2.352+.003/-0.000 TO A LIMIT DIM.	11/16/2012	JAG
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MAT'L OPTION H1075.	10/16/2015	DPD
5	16-0252	CH'D THREAD DIM WAS 3-1/2-16 UN-2B IS 3-1/2-16 UN-1B, ADDED MIN. THREAD RELIEF NOTE.	12/5/2016	RJC

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169871 M.L.S.
18-01-02



DART AEROSPACE	
TITLE BEARING HOUSING	
DWG NO. SWA10A-300	REV 5
MATERIAL: SS 17-4 H1150/H1075	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT: XX	FRACTIONS: $\pm 1/8$
FINISH: .XX	ANGLES: $\pm 5^\circ$
SPEC: .X	SURFACES: ± 125
1. BREAK ALL SHARP EDGES .015 X 45° OR .016R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: CANAM	QA APPR: LINDSAY
CHECKED: MACKOVJAK	APPROVED: GILBERT
OPPS APPR: ANDERSON	
SCALE: 1:2	DATE: 2/21/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	